



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4635-144

Job Sheet 167086-L



Part No: D4635-144

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

DAS
10
985 Dwg Rev F

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	<i>D.M. 19-2-16</i>
100	HandThermo	1 pcs		11/9/17	0.00	1.16	HandFinish4	<i>D.M. 19-2-16</i>
110	Small Fab	1 pcs		11/10/17	0.00	1.57	Small Fab	<i>D.M. 19-2-16</i>
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	<i>33 FEB 20 2018</i>
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	<i>33 FEB 20 2018</i>
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	<i>21 FEB 21 2018</i>

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-4 <i>F164295</i>	1	2	0	0
	D4669-1 <i>500994</i>	1	27	0	0
	D4695-4 <i>5009815</i>	1	2	0	0
	D4732-11 <i>508989</i>	1	5	0	0
	D4732-39 <i>5009005</i>	1	6	0	0
	D4732-41 <i>5009008</i>	1	6	0	0
	D5022-5 <i>5017750</i>	1	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																								
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																																								
Description Work Order Deviation		Disposition																																										
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 02/16/18 Container No: S042980 Part: D4635 - 144 Job No: 167086 - L Serial No/Batch: S042980 Revision: D4635 Inspector:		Master Unit 000950 Job No 167086 - L																																										
Env Equi Har Internal Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">Pressure/Forced</td> <td style="border: none;">☐</td> <td style="border: none;">Temperature/Cure</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Bending</td> <td style="border: none;">☐</td> <td style="border: none;">Set-up</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Centre Not Concentric</td> <td style="border: none;">☐</td> <td style="border: none;">BOM/Route</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Cracks</td> <td style="border: none;">☐</td> <td style="border: none;">Broken/Damage/Defect</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave</td> <td style="border: none;">☐</td> <td style="border: none;">Inspection Incomplete/Unqualified</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Cuffs</td> <td style="border: none;">☐</td> <td style="border: none;">Contamination</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Crushing</td> <td style="border: none;">☐</td> <td style="border: none;">Countersink</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Heat Treat</td> <td style="border: none;">☐</td> <td style="border: none;">Cut Too Short</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube</td> <td style="border: none;">☐</td> <td style="border: none;">Instructions Incomplete/Unclear</td> <td style="border: none;">☐</td> </tr> <tr> <td style="border: none;">Marks/Chatter</td> <td style="border: none;">☐</td> <td style="border: none;">Drill Holes</td> <td style="border: none;">☐</td> </tr> </table>			Pressure/Forced	☐	Temperature/Cure	☐	Bending	☐	Set-up	☐	Centre Not Concentric	☐	BOM/Route	☐	Cracks	☐	Broken/Damage/Defect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Cuffs	☐	Contamination	☐	Crushing	☐	Countersink	☐	Heat Treat	☐	Cut Too Short	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Marks/Chatter	☐	Drill Holes	☐
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